

Work Order ID 144807

144807

Page 1

Monday, April 25, 2016 11:08:30 AM

Item ID: D412-742-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible
 Start Date: 4/25/2016 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/9/2016 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MCS Date: APR 25 2016 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	E	MAY 03 2016	DAS	6					

100 Document Control 0.00
 100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control - USB or Paperwork Photocopy bluefile and create labels per PPP D412-742-013 CHG008

DAS
27
9-89
JUL 11 2016

ECN.
per 16-516
mf

110 Pick Kit 0.00
 110
 Packaging Memo 0.00
 Packaging

MAY 03 2016 DAS
26
9-89

120 QC4- 100% Inspect kits for completeness 0.00
 120
 QC Memo 0.03
 Quality Control

JUL 15 2016 DAS
27
9-89

B147862

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 144807***144807***

Page 2

Monday, April 25, 2016 11:08:30 AM

Item ID: D412-742-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Stop ***NS2***Start Date: 4/25/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: _____								
		<i>Sold</i>							
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS

27

9-89

JUL 15 2016

DAS

21

9-89

JUL 15 2016

2m 16/07/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 1

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC
 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP RevF: add
 AN4C7A DD 10.01.13 verified by: EC IPP Rev: G 11.11.01 as per
 DSI9517 REV.B DD verified by: EC IPP rev: H 12.01.12 PER IIN
 REV.E DD VERF: IPP Rev: I add AN4C47A DD 12.03.14
 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C47A

Purchased

No

110

Each

46.0000

4

4

AN4C47A

Bolt

**

DAS
9-89

DAS
9-89

Location

Loc Qty

Loc Code

FG

10

122491

10

OVER002

12

m134494

12

ST341

24

m134295

12

m134530

12

D412-742-043

Manufactured

No

110

Each

0.0000

1

1

D412-742-043

Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.

D2571

Manufactured

No

110

Each

14.0000

1

1

D2571

Saddle, Fwd, Out

**

**

3147862

MAY 03 2016

DAS
9-89

Location

Loc Qty

Loc Code

ST397

14

142458

12

142664

2

DAS
9-89

MAY 03 2016

DAS
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 2

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2572

Manufactured No

110

Each

16.0000

1

1

D2572

Saddle, Fwd, In

DAS
27
9-89

Location

Loc Qty

Loc Code

ST397

16

142494

4

142495

12

110

Each

18.0000

1

1

D2573

Manufactured No

D2573

Saddle, Aft, Out

DAS
27
9-89

Location

Loc Qty

Loc Code

ST398

18

141101

6

142789

12

D2574

Manufactured No

D2574

Saddle, Aft, In

DAS
27
9-89

Location

Loc Qty

Loc Code

ST398

26

140026

2

143740

12

143741

12

110

Each

37.0000

2

2

D2876

Manufactured No

D2876

Saddle Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST013

37

142706

37

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

DAS
27
9-89

MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 3

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D2877

Manufactured No

110

Each

44.0000

2

2

D2877

Saddle Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST013

44

142762

44

D3403-1

Manufactured No

110

Each

38.0000

8

8

D3403-1

Bushing

DAS
27
9-89

Location

Loc Qty

Loc Code

ST034

38

137648

8

139509

30

D3403-5

Manufactured No

110

Each

36.0000

8

8

D3403-5

Bushing

DAS
27
9-89

Location

Loc Qty

Loc Code

ST035

36

137229

6

139574

30

D2747

Manufactured No

110

Each

240.0000

4

4

D2747

Set Screw

DAS
27
9-89

Location

Loc Qty

Loc Code

ST010

40

141990

40

ST012a

200

143803

200

DAS
26
9-89
DAS
6
9-89

MAY 03 2016

DAS
26
9-89

DAS
26
9-89
DAS
6
9-89

DAS
26
9-89

DAS
6
9-89

MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : *	Step #:	QTY Effective :	MRB (QSI042) Approval		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 4

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3533-1 Manufactured No

110 Each 85.0000 2 2

D3533-1

Set Screw

**

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST041

85

139702

35

144159

50

2

AN4C6A

Purchased No

110 Each 505.0000 16 16

AN4C6A

Bolt

**

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

300

m134502

300

ST345

191

m131410

1

m133990

190

16

AN4C53A

Purchased No

110 Each 45.0000 4 4

AN4C53A

BOLT

**

DAS
26
9-89

Location

Loc Qty

Loc Code

ST340

45

m132795

45

4

DAS
27
9-89

DAS
MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐ _____					

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Monday, April 25, 2016 11:08:35 AM

Page 5

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C52A

Purchased

No

110

Each

78.0000

4

4

AN4C52A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

5

122518

5

OVER002

30

M134130

15

M134131

15

ST340

43

M133091

13

M133336

15

M133921

15

7

DAS
27
9-89

AN6C12A

Purchased

No

110

Each

98.0000

8

8

AN6C12A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

ST335

98

M133363

6

M133694

17

M133992

25

M134573

50

7

DAS
27
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 6

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110

Each

1,381.000

32

32

D3672-3

Washer, Phenolic

★★

DAS
6 26
9-89 9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

68

137234

68

ST051A

1000

139583

500

142571

500

32

DAS
27
9-89

NAS1149C0432R

Purchased

No

110

Each

1,167.000

32

32

NAS1149C0432R

WASHER

★★

DAS
6 26
9-89 9-89

Location

Loc Qty

Loc Code

GA

444

m125807

428

m133790

16

ST266

723

m134073

723

32

DAS
27
9-89

D3672-9

Manufactured

No

110

Each

791.0000

8

8

D3672-9

Washer

★★

DAS
6 26
9-89 9-89

Location

Loc Qty

Loc Code

ST049

261

114963

261

ST051A

530

133084

530

8

DAS
6
9-89

MAY 03 2016

DAS
27
9-89

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐ _____					

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 7

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0632R

Purchased

No

110

Each

106.0000

8

8

NAS1149C0632R

WASHER

DAS 26
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST266

106

M128812

6

M133363

100

D3672-11

Manufactured

No

110

Each

575.0000

8

8

D3672-11

Washer

DAS 26
9-89 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

77483

10

ST049

55

121544

55

ST051A

510

133082

510

MS21043-4

Purchased

No

110

Each

914.0000

29

29

MS21043-4

Nut

DAS 26
9-89 9-89

DAS 6
9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

103

m132803

103

OVER007

300

m134502

300

ST302

471

m133769

171

m134249

300

DAS
27
9-89

MAY 03 2016

29

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : *		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
☐ OTHER : _____									

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3403-3

Manufactured No

110

Each

50.0000

8

8

D3403-3

Bushing

DAS 26
6 8-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST034

40

139644

40

ST0343

10

137786

10

D3405-041

Manufactured No

110

Each

3.0000

1

D3405-041

Ground Handling Lug

DAS
27
9-89

Location

Loc Qty

Loc Code

st529

3

142720

3

D3405-043

Manufactured No

110

Each

2.0000

1

D3405-043

Ground Handling Lug

DAS
27
9-89

Location

Loc Qty

Loc Code

st529

2

142716

2

AN4C7A

Purchased No

110

Each

70.0000

4

AN4C7A

BOLT

DAS 26
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER002

20

m133523

20

ST345

50

m133790

4

m133990

46

DAS 26
6 9-89
9-89

MAY 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 9

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

110

Each

0.0000

1

1

D3407-041

Tow Ring 27 9-89

**

142 671

DAS
6 28
9-89 9-89

D3417-3

Manufactured No

110

Each

49.0000

2

2

D3417-3

Washer

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

FG

7

33519

7

ST035

2

128432

2

ST038A

40

139518

40

D3456-1

Manufactured No

110

Each

129.0000

1

1

D3456-1

Washer

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

FG

7

25701

7

ST038

22

141125

22

ST038A

100

141989

50

144158

50

DAS
27
9-89

MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 9

Picklist Print

Page 10

Monday, April 25, 2016 11:08:35 AM

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C37A

Purchased

No

110

Each

360.0000

1

1

AN3C37A

BOLT

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER002

350

131651

70

M131367

70

M131856

70

M132169

70

M132381

70

ST347

10

M128773

0

M129650

10

AN3C40A

Purchased

No

110

Each

43.0000

1

1

AN3C40A

Bolt

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

5

11442

5

ST347

38

m132717

3

~~m134628~~

15

m134627

20

MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 10

Picklist Print

Page 11

Monday, April 25, 2016 11:08:35 AM

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

344.0000

1

1

AN3C41A

Bolt

Location

Loc Qty

Loc Code

FG

10

122843

5

124975

1

m130081

4

ST338a

225

131651

75

m132169

75

m132522

75

ST347

109

m131367

34

~~m132581~~

75

DAS
27
9-89

MAY 03 2016

DAS
27
9-89

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 12

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C42A

Purchased

No

110

Each

83.0000

1

1

AN3C42A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

5

121103

5

OVER002

50

m132674

10

m133091

10

m133336

10

m134131

10

m134133

10

ST338a

3

m130485

3

ST346

15

m132381

5

m132522

10

ST347

10

m133920

10

DAS
27
9-89

DAS
26
9-89

AN3C43A

Purchased

No

110

Each

50.0000

4

4

AN3C43A

Bolt

DAS
26
9-89

Location

Loc Qty

Loc Code

FG

10

120465

10

OVER002

12

m134509

12

ST346

28

m133363

4

m133932

12

m134502

12

DAS
27
9-89

MAY 03 2016

Monday, April 25, 2016 11:08:35 AM

Shop Packet Print

Page 12

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 13

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

278.0000

5

5

AN3C46A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG	10	
122843	10	
OVER002	210	
M133332	70	
M133917	70	
M134591	70	
ST346	58	
M132169	24	
M132522	34	

MAY 03 2016

NAS1149C0332R

Purchased

No

110

Each

3,545.000

26

26

NAS1149C0332R

WASHER

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001	1864	
m132262	4	
m132930	1004	
m134063	728	
m134073	128	
GA	225	
m133284	225	
ST266	1456	
m134474	456	
m134574	1000	

MAY 03 2016

Picklist Print

Monday, April 25, 2016 11:08:35 AM

Page 14

Work Order ID: 144807

144807

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016

Required Date: 5/9/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

110

Each

1,070.000

13

13

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	385	
m133990	385	
OVER007	400	
m134502	400	
ST302	88	
m133577	88	
ST304	106	
m131340	106	

DAS
27
9809

MAY 03 2016

13

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D412-742

Page 20 of 21

(CONTINUED FROM PAGE 19)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46A	8		D3403-1	BUSHING
46B	8		D3403-5	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49A	4		AN4C52A	BOLT
49B	4		AN4C53A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	8		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		AN4C7A	BOLT
56	2		D3591-1	BUSHING
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C47A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 11.10.19

Work Order ID 144807

Monday, April 25, 2016 11:08:30 AM

144807

Page 1

Item ID: D412-742-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Fits LH or RH High Gear, DART (Apical) Tri-Bag Float Compatible

Start Date: 4/25/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: APR 25 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-742	E	MAY 03 2016							
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D412-742-013		CHG008						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

MLJ MAY 04 2016

see attachment
MLJ

MAY 03 2016

DAS
0.00

Change Record

PAGE 1 OF 1

Part Number: D412-742-013Description: FLOAT SKIDTUBE[illegible]